

**AMENDMENTS TO THE CLAIMS**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

Claim 1 (currently amended): A manufacturing method for a frame body (12) that forms a metal frame body, comprising the steps of:

ring rolling a metal material to form a ring-shaped member (1);  
forming a rectangular member (10) by pressing and deforming the ring-shaped member (1) in radial directions; thereof  
placing the rectangular member (10) in a mold, and;  
pressing and die forging the rectangular member (10).

Claim 2 (currently amended): A manufacturing method for a frame body (12) according to claim 1, wherein when the rectangular member (10) is formed, the angle ( $\theta$ ) of a corner portion (13) that imparts the rectangular shape to the rectangular member (10) is made smaller than the angle ( $\theta_1$ ) in the frame body (12) after die forging.

Claim 3 (currently amended): A manufacturing method for a frame body (12) according to claim 1, wherein when forming the rectangular member (10), an insert (6) is disposed inside the ring-shaped member (1).

Claim 4 (currently amended): A manufacturing method for a frame body (12) according to claim 2, wherein when forming the rectangular member (10), an insert (6) is disposed inside the ring-shaped member (1).

Claim 5 (currently amended): A manufacturing method for a frame body (12) according to claim 1-any one of claims 1 through 4, wherein forming the height (A) of the ring-shaped

member (1) in the axial direction at a height that is equivalent to a plurality of the frame bodies (12) when forming the ring-shaped member (1),

cutting the rectangular member (10) at a height (e) equivalent to the one frame body after forming the rectangular member (10) using this ring-shaped member (1), and die forging these frame bodies (12) separately.

**Claim 6 (currently amended):** A metal frame body (12) comprising wall portions (12a) and (12b), wherein grain flows (20) of the wall portions (12a) and (12b) run in longitudinal directions of the wall portions (12a) and (12b), respectively, and continue with each other.

**Claim 7 (new):** A manufacturing method for a frame body according to claim 2, wherein forming the height of the ring-shaped member in the axial direction at a height that is equivalent to a plurality of the frame bodies when forming the ring-shaped member,

cutting the rectangular member at a height equivalent to the one frame body after forming the rectangular member using this ring-shaped member, and die forging these frame bodies separately.

**Claim 8 (new):** A manufacturing method for a frame body according to claim 3, wherein forming the height of the ring-shaped member in the axial direction at a height that is equivalent to a plurality of the frame bodies when forming the ring-shaped member,

cutting the rectangular member at a height equivalent to the one frame body after forming the rectangular member using this ring-shaped member, and die forging these frame bodies separately.

**Claim 9 (new):** A manufacturing method for a frame body according to claim 4, wherein forming the height of the ring-shaped member in the axial direction at a height that is equivalent to a plurality of the frame bodies when forming the ring-shaped member,

cutting the rectangular member at a height equivalent to the one frame body after forming the rectangular member using this ring-shaped member, and die forging these frame bodies separately.